

Date: Monday, 3/6/2006 1:55:44 PM
 User: Kim Johnston

Process Sheet

| | | | |
|-----------------------|---------------------------------------|------------------|-----------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : HINGE BRACKET PLATE |
| Job Number | : 26077 | | |
| Estimate Number | : 10199 | | |
| P.O. Number | : N/A | Part Number | : D2179 |
| This Issue | : 3/6/2006 S.O. No. N/A | Drawing Number | : D2179 REV. B |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : N/A Type : MACHINED PARTS | Drawing Revision | : B |
| Previous Run | : N/A | Material | : N/A |
| Written By | : <u>SRE COMMENT BELOW</u> | Due Date | : 1/5/2006 |
| Checked & Approved By | : <u>06-03-06</u> | Qty: | 100 Um: Each |
| Comment | : Est A 00.07.0 New Issue EC | | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|--------------|---------------------|
| 1.0 | M5052H32S040 | 5052-H32 .040 Sheet |
|-----|--------------|---------------------|



Comment: Qty.: 0.0096 sf(s)/Unit Total : 0.9555 sf(s)

Material: 5052-H32 (or 6061-T6) 0.040" thick

(M5052H32S.040)

Batch: M15982

ml 06/03/15 (100)

| | | |
|-----|-------|-------|
| 2.0 | SHEAR | SHEAR |
|-----|-------|-------|



Comment: SHEAR

Cut blank: 1.645" x 0.800"

ml 06/03/15 2ty 125 (100)

| | | |
|-----|-------|---|
| 3.0 | HAAS1 | HAAS CNC VERTICAL MACHINING #1 |
|-----|-------|---|



Comment: ~~HAAS CNC VERTICAL MACHINING #1~~

Machine as per Folio FA080 and Dwg D2179

Identify as D2179

HAND MADE

and deburr

ml 06/03/00 2ty 94

| | | |
|-----|-----|--|
| 4.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

N/A

| | | |
|-----|-----|--------------|
| 5.0 | QC2 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

06-03-24 (36)

| | | |
|-----|-------------|-------------------------------|
| 6.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|-----|-------------|-------------------------------|



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble and Deburr

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: D2179 PAR #: N/A Fault Category: Red / FAB. ASS' next small NCR: Yes No DQA: [Signature] Date: 06/04/10
 QA: N/C Closed: [Signature] Date: 06/04/10

| NCR: <u>26077</u> | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|-------------------|------|---|--------------------------------|---------------------------------|--------------------------------|--------------------------------|--------------------------------|--------------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 06/03/20 | 03 | Scrap 31 parts Holes off dimension | <u>[Signature]</u> 04/03/20 | destroy them No replace | <u>[Signature]</u> 06/03/20 | <u>[Signature]</u> 06-03-28 | <u>[Signature]</u> 04/03/28 | <u>[Signature]</u> 06-03-28 |
| 06-03-28 | 03 | 56 parts no good, holes too close together by .025" → .035" will spread holes open during ass'y causing tearing in the mat'l. | <u>[Signature]</u> 04/03/28 | Scrap, NO replace | <u>[Signature]</u> 06-03-28 | <u>[Signature]</u> 06-03-28 | <u>[Signature]</u> 04/03/28 | <u>[Signature]</u> 06-03-28 |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Monday, 3/6/2006 1:55:44 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HINGE BRACKET PLATE

Job Number: 26077

Part Number: D2179

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

DL 06/03/29

(38)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a.m 06-04-05

(38)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

MA

06 04 05

(38)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST027

AR 06/04/06

(38)

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DP

06/04/10

(38)

Job Completion



u 06-04-10

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

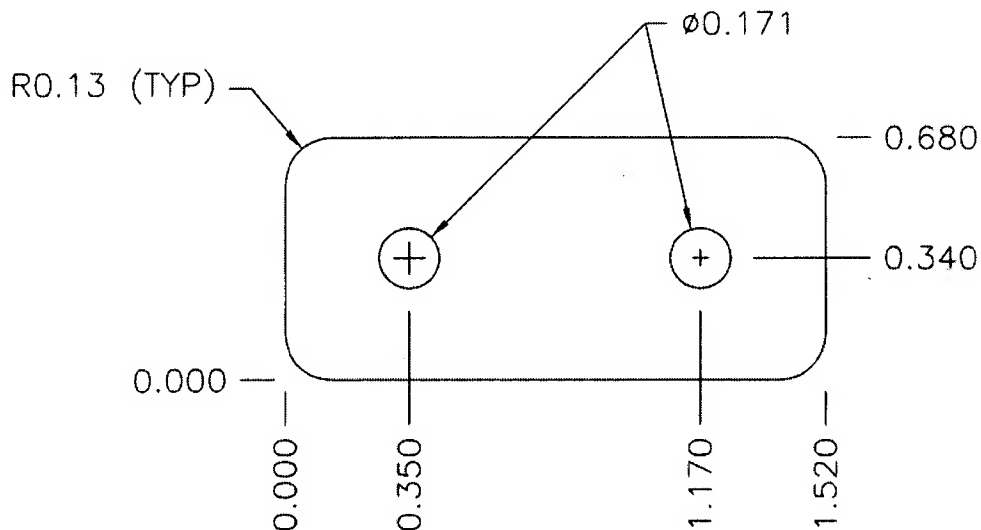
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



| | | | |
|-------------------------------|--------------------------------|---|------------------------|
| DESIGN KH | DRAWN BY RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D2179 | REV. B SHEET 1 OF 1 |
| DATE 00.06.20 | | TITLE HINGE BRACKET PLATE | SCALE 2:1 |
| A | 95.03.17 | NEW ISSUE | |
| B | 00.06.20 | DWG No. D2179 WAS D2399 | |

RELEASED
ord. 27 *[Signature]*



MATERIAL: 5052-H32 (QQ-A-250/8) OR 6061-T6 (QQ-A-250/11)
OR 2024-T3 (QQ-A-250/4) 0.040 THICK
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 26077

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